

Work Order ID 113346 -1

February-28-14 9:18:15 AM

113346

Page 1

Item ID: D4775-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Strut Assembly

Start Date: 2/12/14 Start Qty: 19.00

19

Cust Item ID:

Required Date: 2/12/14 Req'd Qty: 19.00

19

Customer:

Reference:

Approvals: Process Plan: MCT

Date: 14-02-13 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4775

C

110

Pick Kit

0.00

110

Large Fab

Packaging

Memo

0.00

Packaging

19x

DAS
28
3-08

14-02-28

120

0.00

120

Small Fab

Memo

0.00

Small Fab

1- APPLY PROSEAL ON D4776-1 STRUT AND ASSEMBLE AS PER DWG

A/R PROSEAL BATCH: 127662

2- ENSURE HELICOIL DOES NOT BLOCK HOLE (SEE NOTE 9)

2

FF
14-03-03

Work Order ID 113346

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Page 2

Item ID: D4775-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Strut Assembly
 Start Date: 2/12/14 Start Qty: 19.00 ***19*** Cust Item ID:
 Required Date: 2/12/14 Req'd Qty: 19.00 ***19*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				2			
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00							
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

14/3/4 (2)

MCS 14-03-04

14-03-04

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113346

D4775-041

Start Date: 2/12/14

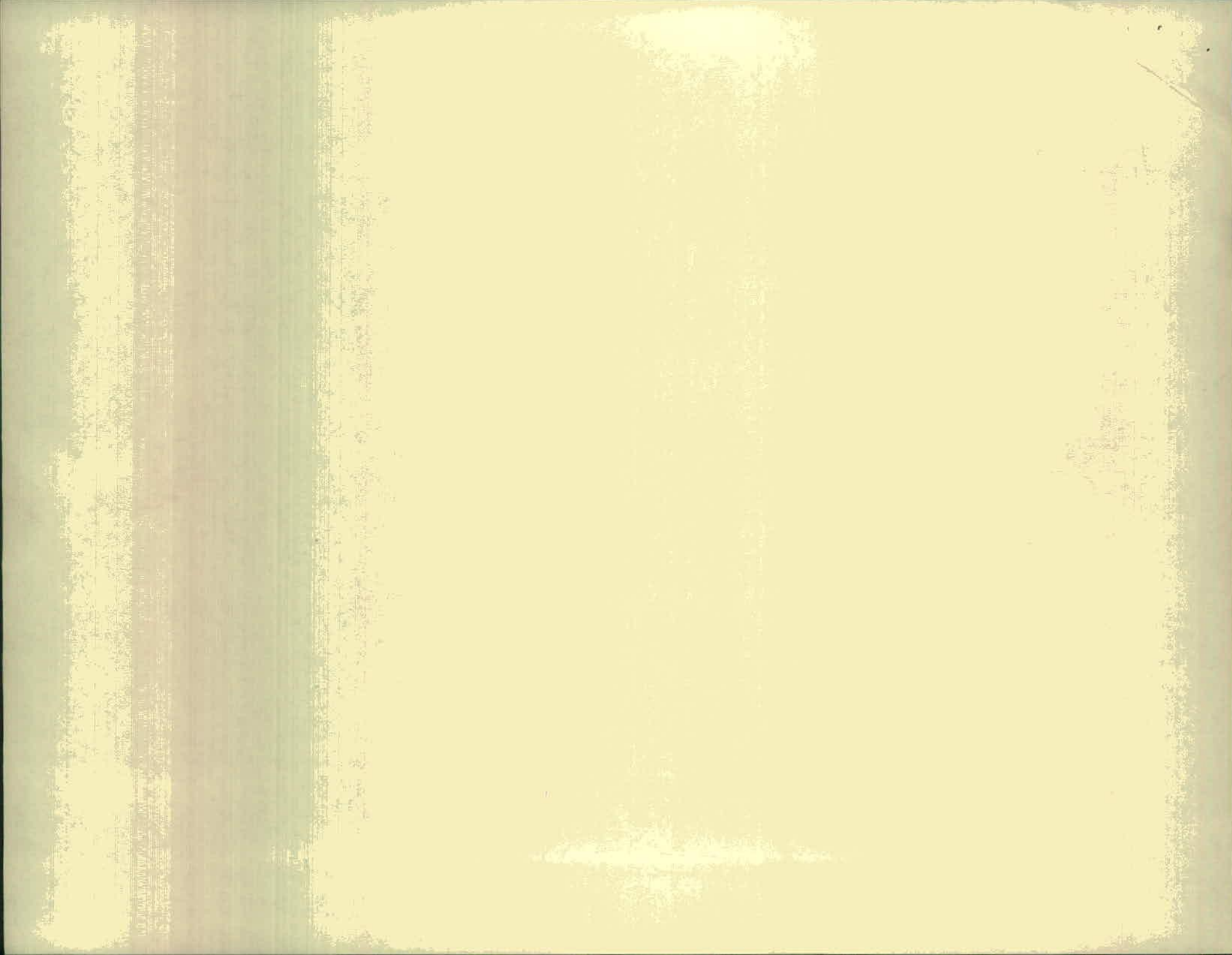
Required Date: 2/12/14

Start Qty: 19.00

Required Qty: 19.00

Comments: IPP REV:A 13.02.28 NEW ISSUE DD VERF:JFS IPP
REV:B 13.08.26 PB1 DD VERF:JLM IPP REV:C
13.09.26 AS PER REV.B DD VERF:JLM IPP REV:D 14.01.10
AS PER REV.C DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4775-1		Manufactured	No			110	Each	0.0000	1	19			
D4775-1					11360				**	42	FF	14-03-03	
Strut Tube													
D4777-1		Manufactured	No			110	Each	20.0000	1	19			
D4777-1									**			DAS 28 9-89	
Rod End Bearing													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST123		20							
				110971		4				3x			
				<u>112383</u>		16				<u>16x</u>			
D4776-1		Manufactured	No			110	Each	20.0000	1	19			
D4776-1									**			DAS 28 9-89	
Basket Strut Clevis													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST123		20							
				110934		4				3x			
				<u>112327</u>		16				<u>16x</u>			
D4776-5		Manufactured	No			110	Each	136.0000	4	76			
D4776-5									**			DAS 28 9-89	
Spacer													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST123		136							
				111095		3							
				<u>111610</u>		33				<u>33x</u>			
				<u>112597</u>		100				<u>43x</u>			



Picklist Print

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Work Order ID: 113346

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Parent Item: D4775-041

D4775-041

Parent Item Name: Strut Assembly

Start Date: 2/12/14

Required Date: 2/12/14

Start Qty: 19.00

Required Qty: 19.00

AN3-10A

Purchased

No

110

Each

141.0000

2

38

AN3-10A

Bolt

**

DAS
28
9-89

14-02-28

Location

Loc Qty

Loc Code

ST351

141

m127817

141

38x

MS21042L3

Purchased

No

110

Each

3,743.000

2

38

MS21042L3

Nut

**

DAS
28
9-89

Location

Loc Qty

Loc Code

ST314

2788

M127410

2747

M127831

41

38x

ST506

955

123900

955

MS21209-F615

Purchased

No

110

Each

8.0000

1

19

MS21209-F615

Hel-Coil

**

FF 14-03-03

Location

Loc Qty

Loc Code

GA

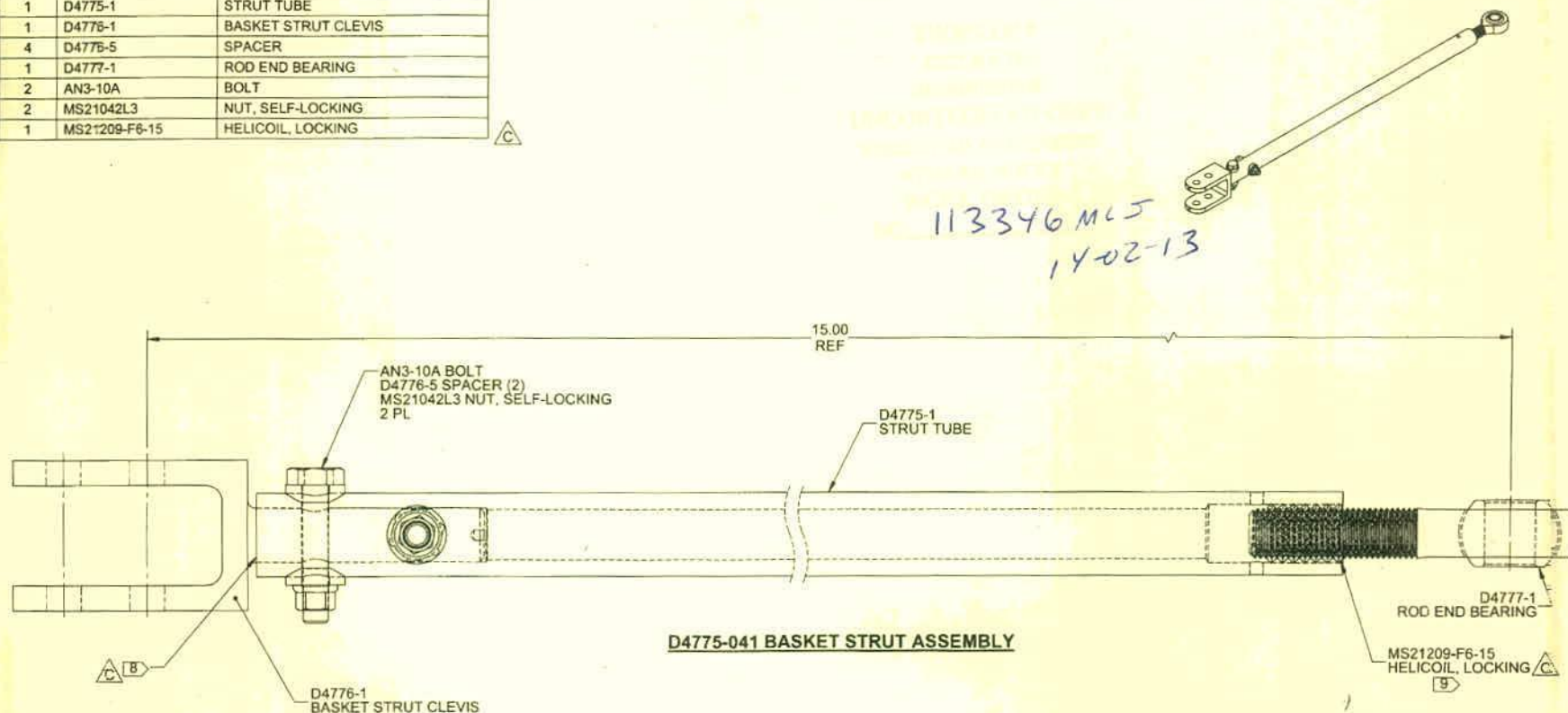
8

125097

8

82

ITEM	QTY	P/N	DESCRIPTION
	X	D4775-041	BASKET STRUT ASSEMBLY
1	1	D4775-1	STRUT TUBE
2	1	D4776-1	BASKET STRUT CLEVIS
3	4	D4776-5	SPACER
4	1	D4777-1	ROD END BEARING
5	2	AN3-10A	BOLT
6	2	MS21042L3	NUT, SELF-LOCKING
7	1	MS21209-F6-15	HELICOIL, LOCKING

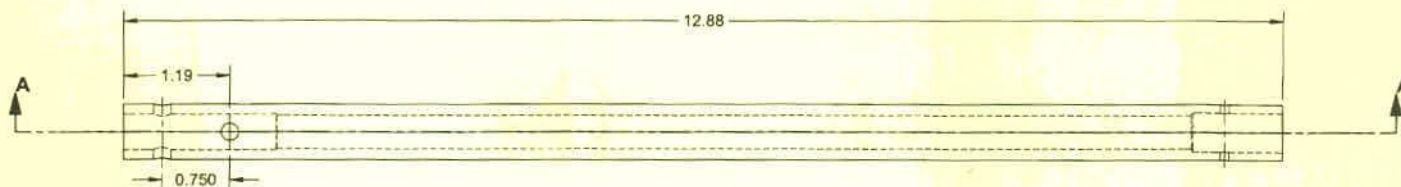


D4775-041 BASKET STRUT ASSEMBLY

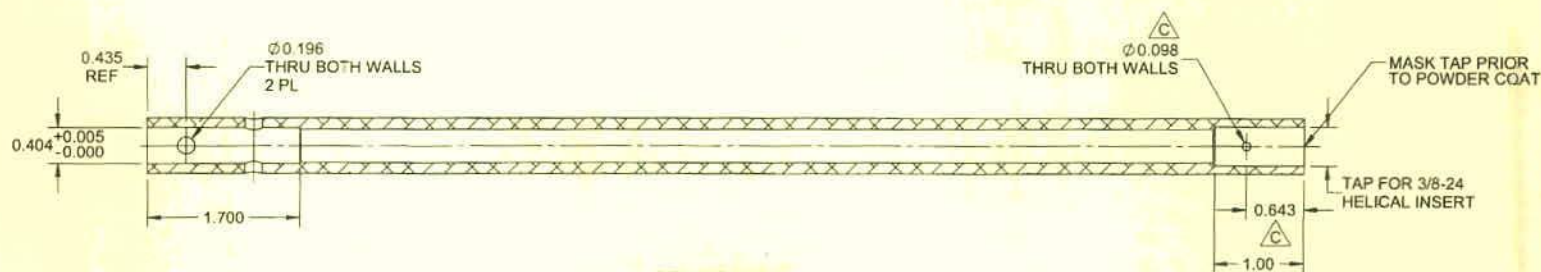
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.45 lbs
- 8) APPLY PROSEAL 890 B-2 (PRC) TO THE STEM OF ITEM 2 TO PREVENT RATTLING.
- 9) ENSURE HELICOIL DOES NOT BLOCK HOLE

C	ITEM 7 WAS F6-20, B2-2 Ø0.098 "WITNESS HOLE" ADDED. REASON: CUSTOMER FEEDBACK. ADDED NOTE 8. REASON: DESIGN IMPROVEMENT.	AJS	13.11.01
B	DELETED WELD PINS (-3) REPLACED WITH FASTENERS. REASON: PREVENT CRACKING & EASE OF MANUFACTURE. C6-2 HOLE PATTERN ON -1 REVERSED TO ENSURE FASTENERS CLEAR STRUCTURE. FINISH NOTE MOVED TO -1 (SHEET 2).	AJS	13.08.14
A	NEW ISSUE	AJS	13.06.08
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	A.P.	DRAWING NO.	REV. C
MFG. APPR.		D4775	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BASKET STRUT ASSEMBLY	NTS
DATE	13.11.01	<small>COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D4775-1 STRUT TUBE



SECTION A-A

NOTES:

- 1) MATERIAL: 6061-T6/T62/T6510/T6511 SEAMLESS TUBING, $\phi 0.625 \times 0.125$ WALL PER WW-T-700/6 OR QQ-A-200/8 OR QQ-A-225/8 OR AMS 4080 OR AMS 4082 OR AMS 4083 OR ASTM B210 OR ASTM B241 REF DART SPEC M6061T6T0.625W0.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.24 lbs

RELEASED
2014-01-08

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. C
MFG. APPR.		D4775	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BASKET STRUT ASSEMBLY	NTS
DATE	13.11.01	COPYRIGHT © 2013 BY DART AEROSPACE LTD.	

